

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029796**Date Inspected:** 18-May-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Salvador Merino**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

Caltrans Office of Structural Material (OSM) Quality Assurance Inspector (QAI) Joselito Lizardo was present at the Self Anchored Suspension (SAS) job site as requested to perform observations on the welding of components for the San Francisco Oakland Bay Bridge (SFOBB) Project.

Today, this QA was tasked to walkthrough with ABF QC Salvador Merino on the top deck plate of the OBG wherever access is available. The following locations were visually inspected and found defects on the top side of the deck;

Lift # PP # X-dist. Line Y-dist. Type of Defect

7E PP56 +1180mm E4 +1900 Weld Arc Strike

7E PP56 +1470 E4 +1160 Weld Arc Strike

7E PP56 +2850 E4 +900 Weld Arc Strike

7E PP56 +3600 E4 +1400 Weld Arc Strike

10E PP91 +2000 E4 +2800 Weld Arc Strike

10E PP91 +2100 E4 +1200 Weld Arc Strike

11E PP105 +600 E4 +2400 Weld Arc Strike

3W PP21 -1800 W3 +1500 Weld Arc Strike

3W PP21 -450 W3 +4500 Sharp gouge

3W PP23 -800 W3 +1500 Sharp gouge

5W PP29 +900 W3 +1710 Sharp gouge

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## WELDING INSPECTION REPORT

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5W PP31 -1700 W3 -2200 Sharp gouge  
8W PP61 +0 W3 +1720 Weld Arc Strike  
8W PP62 -1200 W3 +4000 Sharp gouge  
8W PP63 -300 W3 +4800 Sharp gouge  
8W PP66 +1500 W3 +1200 Sharp gouge  
8W PP66 +3100 W3 +1000 Sharp gouge  
8W PP68 -500 W4 -900 Sharp gouge

After the completion of the top deck plate walkthrough, this QA has observed ABF welder Jose Torres perform 5mm fillet welding all around padeye to luminaire post. The welder was noted welding using Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode. The welder was noted welding at location Panel Point PP13.5 E5 of the east bound OBG. During welding, ABF QC William Sherwood was noted monitoring the parameters and workmanship of the welder.



### Summary of Conversations:

No significant conversation occurred today.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Gary Thomas 916-764-6027, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Lizardo, Joselito	Quality Assurance Inspector
<b>Reviewed By:</b>	Reyes, Danny	QA Reviewer

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